Work Order ID 56696 Page 1 March 4, 2010 12:42:49 PM Item ID: D3704-1 Accept Setup Start Revision ID: Stop Item Name: **ESCUTCHEON** Start Date: 3/05/10 Start Oty: 5.00 Cust Item ID: Required Date: 3/12/10 Reg'd Qty: 5.00 Customer: Reference: Start Run Date: 10-3-04 Tooling: Process Plan: Approvals: Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Draw Draw Plan Accept Reject Reject Insp. Work Center ID Description Number Rev. Oty **Run Hours** Code Oty Number Stamp Draw Nbr Revision Nbr D3704 Rev B 100 0.00 BAND SAW HA 10/03/10 0.00 Bandsaw Memo Jeaspa Bandsaw Cut blank 3.00 " long 110 0.00 A 10.3.11 HAAS CNC VERTICAL MACHINING #1 HAAS 1 Memo I- Mill as per Folio FA730 Rev: A & Dwg D3704 Rev: 8 02-Deburr HAAS CNC vertical machine #1 per dwg D3704 0.00 of co. 3.11 QC2- Inspect parts off machine FAI/FAIB 120 0.00 Memo

40. 5

Quality Control

Dart Aerospace Ltd WORK ORDER CHANGES W/O: Approval Approval DATE STEP PROCEDURE CHANGE By Qty Date Chief Eng / QC Inspector Prod Mgr Part No: ______ PAR #: _____ Fault Category: ______ NCR: Yes No DQA: ____ Date: ____ Resolution: _____ Disposition: _____ QA: N/C Closed: ____ Date: ____ WORK ORDER NON-CONFORMANCE (NCR) NCR: **Corrective Action** Section B Description of NC Verification Approval Approval STEP DATE Sign & **Action Description** Initial Section A Section C QC Inspector Chief Eng Date Chief Eng Chief Eng

Work Order ID 56696

March 4, 2010 12:42:49 PM



Page 2

Item ID:

D3704-1

Accept

Setup Start



Revision ID:

Item Name:

ESCUTCHEON

Start Date:

3/05/10

QC:

Required Date: 3/12/10

Req'd Qty: 5.00

Start Qty: 5.00



Cust Item ID:

Customer:

Approvals:

Reference:

Process Plan:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run

Start

Stop



Stop

Sequence ID/ Work Center ID

130

Quality Control

Operation Description

QC8- Inspect parts - second check

Memo

Set Up/

Run Hours 0.00

S. 8 10/03/11

Draw Draw Number Rev.

Plan Code

Accept Qty

5

Reject Qty

Reject Insp. Number

Stamp

140

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

0.00

0.00

0.00

6/ 10-3-15

150

Quality Control

QC3- Inspect Part Finish

Memo

Dart	Aerospace	Ltd
W/O:		

W/O:			WO	RK ORDER CHANG	ES							
DATE	STEP	PRO	OCEDURE CHAP	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQ	A:	_ Date: _	Date:			
Resolution:			Disposition	i:	QA: N/C CI	osed:	<u> </u>					
NCR:		3	WORK ORDE	ER NON-CONFORM	ANCE (NCF	R)						
DATE	STEP	Description of NC			ion B	Verifi	cation	Approval	Approval			
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Sect	ion C	Chief Eng	QC Inspector			
pr												
						+						
									1			
									1 2			

Work Order ID 56696

March 4, 2010 12:42:54 PM



Page 3

Item ID:

D3704-1

Accept

Setup Start



Revision ID:

Item Name:

Required Date: 3/12/10

ESCUTCHEON

Start Date:

3/05/10

QC:

Start Qty: 5.00

Req'd Qty: 5.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: Date:

Tooling:

Date:

Date:

Run

Start

Stop



Stop



Sequence ID/ Work Center ID

160

Packaging

Packaging

170

Operation Description

Identify as per dwg & Stock Location:

Memo

Set Up/ Run Hours

SPC (Y/N):

0.00

0.00

Draw Number

Draw Rev.

Plan Code Qty

Accept

Reject Qty_

Reject Insp. Number Stamp

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/03/19 A) MF 10-3-16

Quality Control

Dart Aerospace Ltd

	7										
W/O:			WC	ORK ORDER CHANG	ES				8		
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
									15		
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date:			
Resolution:			Disposition	n:	QA: N/C Clo	sed:					
NCR:			WORK ORDI	ER NON-CONFORMA	NCE (NCR)			-		
DATE	STEP	Description of NC		on B	Verific	cation	Approval	Approval			
DATE	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date		ion C	Chief Eng	QC Inspector		
									1		
								2			

Picklist Print

March 4, 2010 12:40:22 PM

Work Order ID: 56696

Parent Item: D3704-1

Parent Item Name: ESCUTCHEON

Comments:

IPP Rev:A New Issue 08-04-01 JLM Verified By:DD

110167

Start Date: 3/05/10

Required Date: 3/12/10

Page

- Committee of the control of the co	IFF Kev.A New I	ssue 08-04-01	JLM	Verified By:I	DD			3	Start Qty: 5.00		Required Qty:	5.00
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B0.750X01.50 0		Purchased	No				f	8.7342	1,3000	133464	issued	PHEM

6061-T6 Bar .750 X 1.50

Warehouse Loc Qty Loc Code Location Main Warehouse MAT 8.73419949

8.73419949

1.2700ft H.A 10/03/10

DATE STEP PROCEDURE CHANGE By Date Qty Approval Chief Eng / Prod Mgr QC Inspector

Part No:		PAR #:	Fault Cated	gory:	NCR: Yes N	o DQA:	_ Date: _	
	Resolution:		Disposition: Q		QA: N/C Clos	A: N/C Closed:		
NCR:			WORK ORDE	ER NON-CONFORMAN	NCE (NCR)	1,1		4 1
		Description of NC	1	Corrective Action Section	В	Verification	Approval	Approval QC Inspector
DATE STI	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	

DART AEROSPACE LTD	Work Order:	56191
Description: Escutcheon		- 44
The state of the s	Part Number:	D3704-1
Inspection Dwg: D3704 Rev: B		
WOY, D		Page 1 of 1

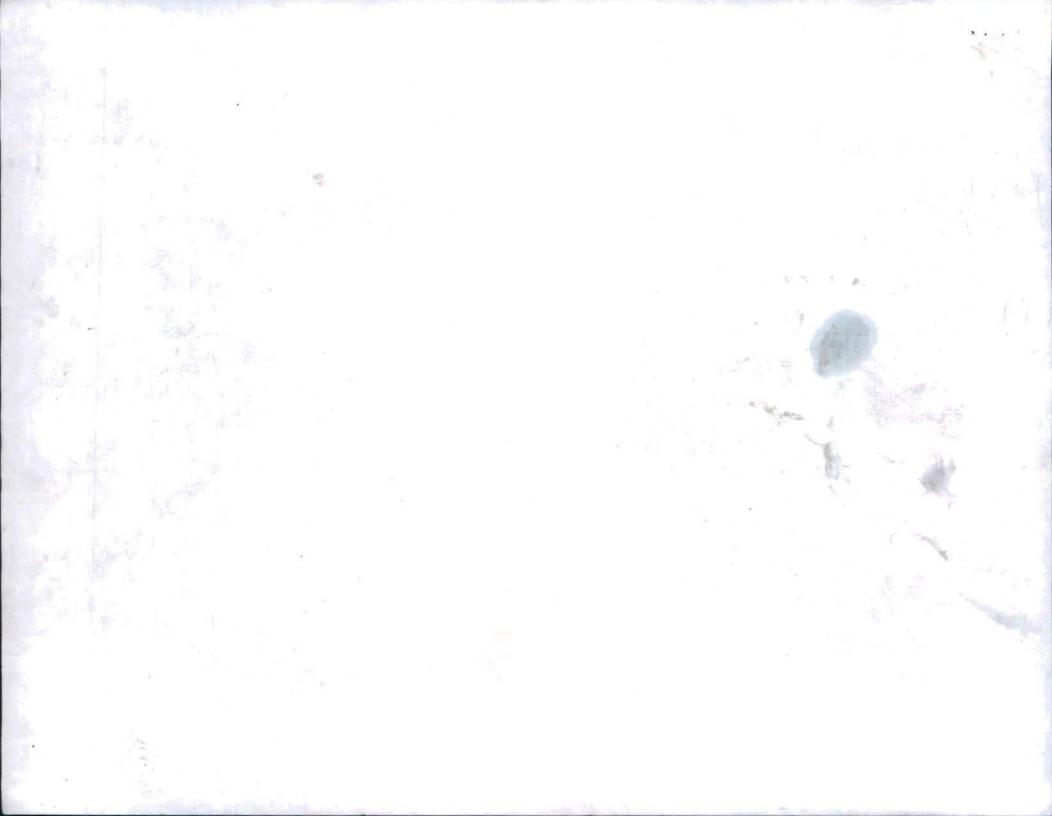
FIRST ARTICLE INSPECTION CHECKLIST

X	

Drawing Dimension		Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.125	+/-0.010	2.125			inspection	
1.063	+/-0.010	1.063				
0.610	+/-0.010	.610				
1.22	+/-0.030	1.229				
Ø0.170	+0.005/-0.001	.171	-			
Ø0.322 x 100°	+/-0.010 x +/-0.5°	.320				
0.125	+/-0.010	.127				
0.125	+/-0.010	. 130				
0.500	+/-0.010	- 497				
0.625	+/-0.010	.620				
2.88	+/-0.030	2.887				
0.218	+/-0.010	-215				
0.080	+0.000/-0.005	. 077				
Ø0.640	+0.005/-0.001	. 42		-		
Ø0.935	+0.005/-0.001	. 937				
0.030 x 45°	+/-0.010 x +/-0.5°	.03×45				
R0.03		203				
					The latest light to	
					10 14 52	

leasured by:	A		
Date: 10. 3.11	Audited by: 3 6	Prototype Approval:	N/A
Date. 78. 3. 11	Date: 10/03/11	Date:	N/A

Kev	Date	Change		
A	10.02.02	New Issue	Revised by KJ	Apptoved
			KJ 9C	AA.
			1/1	



D3704-1 ESCUTCHEON B D3704-3 ESCUTCHEON SHOP COPY RETURN TO **ENGINEERING** UNCONTROLLED COPY SUBJECT TO AMENDMENT NOTES:

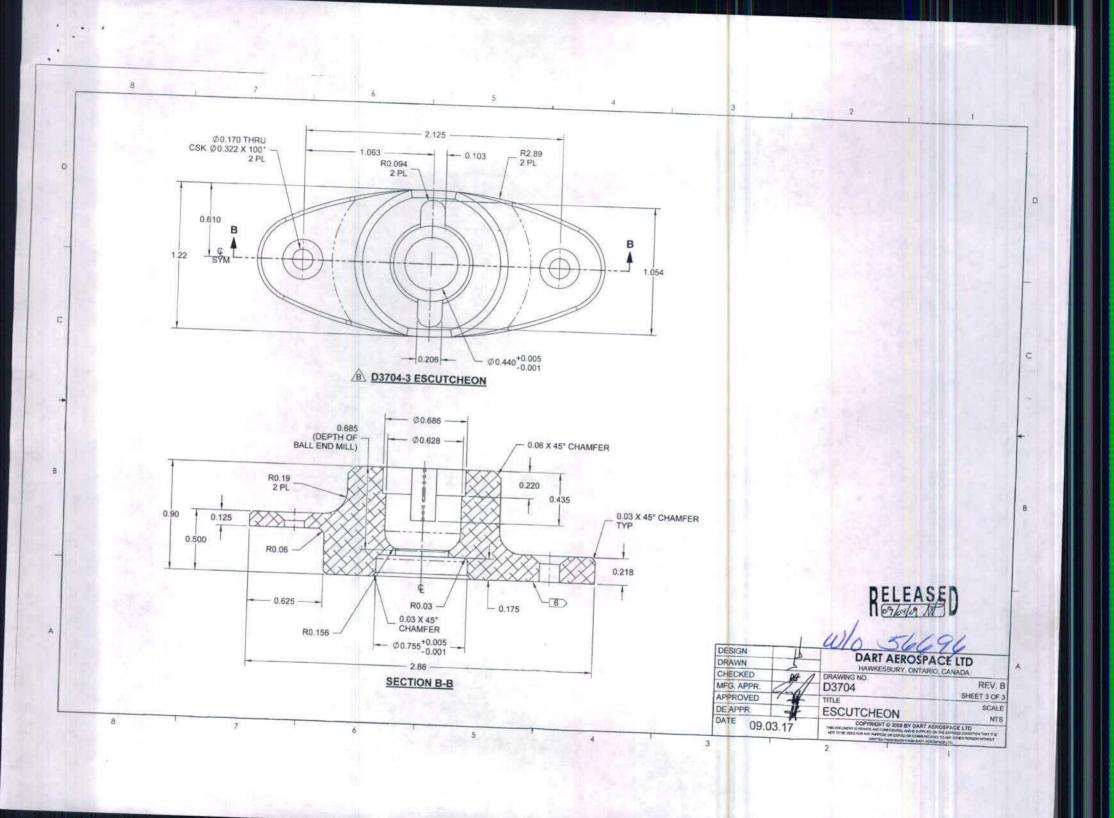
1) MATERIAL: 6061-T6 (OR 6061-T651/-T6510/-T6511/-T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061768)

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3704-X" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT:
- D3704-1 = 0.04 lbs WITHOUT NOTICE ADDED D3704-3. REASON: COMPATIBILITY WITH AAPS MB 09.03.17 A NEW ISSUE MB REV 08.02.05 DESCRIPTION BY DESIGN DATE DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. MFG. APPR. REV. B D3704 - D3704-1 = 0.04 lbs - D3704-3 = 0.11 lbs APPROVED SHEET 1 OF 3 TITLE DE APPR SCALE **ESCUTCHEON** DATE NTS COPYRIGHT & 2008 BY DART AEROSPACE LTD
IT IS INNATE AND COMPENSION, AND INJURY OF THE CONTRIBUTION OF COMPENSION FOR COMPENSION OF COMPENSION FOR COMPENSION OF COMPENSION 09.03.17

	×
* C 0	

Ø0.170 THRU CSK Ø0.322 X 100* R2.89 2 PL 1.063 -2 PL 0.610 1.22 R0.38 2 PL IN THIS AREA: 0.25 MAX D3704-1 ESCUTCHEON 0.125 R0.19 - 0.080^{+0.000} -0.005 0.03 X 45" CHAMFER 0.125 TYP R0.03 2 PL 0.500 R0.06 0.218 Ø0.640^{+0.005} 0.03 X 45° 0.625 CHAMFER - Ø0.935^{+0.005} - 2.88 SECTION A-A DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. MFG. APPR. D3704 REV. B APPROVED SHEET 2 OF 3 TITLE SCALE DE APPR ESCUTCHEON NTS DATE COPYRIGHT © 3006 BY DART AEROSPACE LTD.
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